Work Order ID 60561 Page 1 Wednesday, July 14, 2010 9:17:46 AM Item ID: K10003 Accept Setup Start **Revision ID:** Stop Saddle, D205-634-011 Item Name: **Start Date:** 7/14/2010 Start Qty: 4.00 **Cust Item ID:** Required Date: 7/22/2010 Req'd Qty: 4.00 **Customer:** Reference: Run Start Date: 10-7-14 Tooling: Approvals: **Process Plan:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool # Plan Set Up/ Tool ID Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Qty Code **Qty** Number Stamp Draw Nbr **Revision Nbr** IIN634,635 Rev F 100 0.00 DOCUMENT CONTROL 0.00 Memo Document Control Create White labels only per PPP K10003 110 Pick Kit 0.00 Packaging 0.00 Memo Packaging 120 QC4-100% Inspect kits for completeness 0.00 0.00 Memo Quality Control

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRC	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No		PAR #:	Fault Cate	gory:	NCF	R: Yes	No DQ	A:	Date:				
Resolution:		Disposition	n:	QA:	N/C CI	osed:		Date:					
NCR:		1	WORK ORD	ER NON-CONFORM	ANCE	(NCF	R)						
DATE	STEP	Description of NC	Corrective Action S Initial Action Descriptio		ction B	Sign 8		cation	Approval	Approval			
		Section A	Chief Eng	Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector			
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Work Order ID 60561 Wednesday, July 14, 2010 9:17:46 AM												Page 2
Item ID: Revision ID:	K10003			Accept					Setup		1 18811181 6	
	Saddle, D205 7/14/2010 7/22/2010	Start Qty: 4.00 Req'd Qty: 4.00			Cust Item I Customer:	D:				Stop		
Approvals:	Process Pla		Date:	Tooling: SPC (Y/N):		ite:			Run	Star Stop		
Sequence ID/ Work Center II 130 Packaging Packaging	•	Operation Description Identify as per dwg & Stock Memo	* Location:	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	ject y	Reject Number	Insp. Stamp

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/1348) CX10/9/13

63

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W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	CEDURE CHA	NGE	E	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	·	PAR #:	Fault Cate	gory:	NCR:	Yes N	o DQ /	\:	Date:	<u> </u>			
Resolution:			Disposition	n:	QA: N	/C Clos	sed:		Date: _	<u> </u>			
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR)							
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section B Initial Action Description			Sign & Verification C		Approval Chief Eng	Approval QC Inspector			
		Section A	Chief Eng	Chief Eng		Date	Section	JII C	Office Ling	QO mapecioi			
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Wednesday, July 14, 2010 9:17:50 AM

Work Order ID: 60561

Parent Item:

K10003

Parent Item Name: Saddle, D205-634-011



Start Date: 7/14/2010

Required Date: 7/22/2010

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Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP: I□ 03.01.16 Reformat: Incorporated D205-641-011

IPP: J 06-07-25 As per DSI 9344

IPP: K 06.11.17 Per K10003 Rev C

KJ IPP: L 07.01.12 Document Record for copying bluefile rmv KJ IPP Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified by:

IPP N 09.01.27 DSI 9418 rev B EC verified by: DD

Purchased

AN4-51A	 					Hand		Qty	Issued	Issued	
Bolt	Purchased	No		110	Each	167.0000	8_ 1	10/9/	35/	,	
1			Location	Loc C	<u>Qty</u>	Loc Code			ľ		
			ST360		167				_ ^		

KJ/RF□

JLM

and a
AÑ4-6A
-
Bolt

	ST360		167	
	114941		167	
No	•	110	Each	1,260.000
	•			

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0	16	64)	
		10/9/2	SY

		Location	<u>L</u>	oc Oty	Loc Code		
		ST356		1260			
		112933		96			
		113149		361			
		114523		2			
		114615		1			
		114941		500			63
		115108		300			
Purchased	No		110	Each	11.0000	4	116 6x MU 5731



Location Loc Oty Loc Code ST361 11 115030 11

M115231 M1/5358 M115352 (07) 10/9/34

W/O:			W	ORK ORDER CHAN	GES				· ·	20
DATE	STEP	PRO	CEDURE CH	ANGE	В	y	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	Part No: PAR #:									
									Date:	
NCR:			VORK ORL	DER NON-CONFORM	/IANCE (P	ICH)				
DATE	STEP	Description of NC			ection B		Verific	ation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Description Sign & Date		Section C		Chief Eng	QC Inspector
				•						
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Wednesday, July 14, 2010 9:17:50 AM

Work Order ID: 60561

Parent Item:

K10003

Parent Item Name: Saddle, D205-634-011



Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 4.00

222.0000

Loc Code

0.0000

559.0000

Required Qty: 4.00

AN6-12A

No

NAS1149D0463J Purchased

Purchased

No

No

Washer

NAS1149D0663J Purchased

Washer

D2570

Manufactured No

Location Loc Oty ST342 222 114523 22

110

110

110

114941

110 Each

200

Each

Each

Each

0.0000

M115000

96

128

Location	Loc Qty	Loc Code
ST018	559	
59911	45	
60288	313	
60476	201	

Wednesday, July 14, 2010 9:17:50 AM

Shop Packet Print

Page 2

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W/O:			WO	RK ORDER CHANGE	S				7.
DATE	STEP	PRO	OCEDURE CHAP	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Resolution:		esolution:	Disposition	1:	QA: N/C Cld	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			,
DATE	CTED	Description of NC			n B	Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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Wednesday, July 14, 2010 9:17:50 AM

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Work Order ID: 60561

Parent Item:

K10003

Parent Item Name: Saddle, D205-634-011



Location

43564 47564

58250 59298 59849

ST425

ST433

Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 4.00

Required Oty: 4.00



D2571

Manufactured

110

Each

25.0000

Loc Code

_	D2572
S_{AA}	

D2573

Saddle, Fwd In 205

Manufactured

No

Loc Qty 17 110 Each

15.0000

 Manufactured	No

Location	<u>Lo</u>	c Qty	Loc Code
ST425		4	
43565		4	
ST433		11	
, 59300		2	
59850		9	
	110	Each	8.0000

Location	Loc Qty	Loc Code
ST425	8	
43566	4	
47566	4	

Dart Aer	ospace	e Ltd						1 , 5
W/O:			V	VORK ORDER CHANGES	<u> </u>			,
DATE STEP		PRO	CEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA:	Date: _	1
	R	esolution:	Disposit	ion:	QA: N/C CI	osed:	Date: _	
NCR:		V	ORK OR	DER NON-CONFORMAN	ICE (NCF	R)		
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C	Chief Eng	QC Inspector

	WORK ORDER NON-CONFORMANCE (NCR)						
	Description of NC	Posseription of NC Corrective Action Section B			Verification	Approval	Approval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
			d				
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Chief Eng Corrective Action Section B Action Description Chief Eng	STEP Description of NC Section A Chief Eng Chi	STEP Description of NC Section A	STEP Description of NC Section A Chief Eng Chi

Required Date: 7/22/2010

Required Qty: 4.00

Wednesday, July 14, 2010 9:17:50 AM

Work Order ID: 60561

Parent Item:

D2574

K10003

Parent Item Name: Saddle, D205-634-011



Location

Location

Location

ST028

ST023

ST425

Saddle, Aft In 205

Manufactured

No

110

Each

4

Each

4.0000

Loc Code

Start Date: 7/14/2010 Start Qty: 4.00

Manufactured No 43567

110

Loc Qty

Loc Qty

Loc Qty

Loc Qty

44

44

133

29

49

2 47

Each

133.0000

Loc Code

D2876

Saddle Spacer

Manufactured

Manufactured

No

51921 59879

39224

42364

51540 -

110

100 Each

49.0000

Loc Code

44.0000

Location ST028 <u>585</u>31

İ10

Loc Code

W/O:		(Manufacture of the Control of the C	WC	RK ORDER CHANGI	ES				
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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								i ·	
									·
Part No: PAR		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	Resolution: Disposition:			ı:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC	Corrective Action		———— Verifica			Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
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Wednesday, July 14, 2010 9:17:50 AM

Work Order ID: 60561

Parent Item:

Parent Item Name:

K10003



Saddle, D205-634-011

Start Date: 7/14/2010

Required Date: 7/22/2010

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Start Qty: 4.00

Required Oty: 4.00

D3405-041

Lug Assembly

D3405-043

H Lug Assembly

Manufactured

No

110

110

Each

4.0000

Loc Code

Manufactured No Location ST474

Location

ST474

59628

53888 59629 Loc Qty

Each

8.0000

D3407-041

D3417-5 \Washer

Ø,

Manufactured No

Manufactured

No

110

7 Each

Loc Qty

24.0000

Loc Code

Location ST464

Loc Qty 24 12 12 110 Each Loc Code

71.0000

Location ST056

Loc Qty 71 31

40

Loc Code

Dait Aei	Uspace	Liu							, , ,		
W/O:			WC	RK ORDER CHANG	ES				» ·€		
DATE	STEP PROCEDURE CHANGE			NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							_				
Part No		PAR #:		-							
Resolution: Disposition: _								Date: _			
NCR:		\	WORK ORDI	ER NON-CONFORMA	NCE (NCI	₹)					
DATE	OTED	Description of NC	Corrective Action		on B	Verifi	cation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section C		Sign & Section C		Chief Eng	QC Inspector
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Wednesday, July 14, 2010 9:17:50 AM

Work Order ID: 60561

Parent Item:

K10003

Parent Item Name: Saddle, D205-634-011



110

Start Date: 7/14/2010

Required Date: 7/22/2010

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Start Qty: 4.00

Required Qty: 4.00



D3533-1

D3456-1

Manufactured

Manufactured

No

No

Location Loc Qty ST058 56 54692 56 110

Loc Code Each

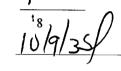
Each

83.0000

Loc Code

Loc Code

56.0000



MS21042L4

Purchased No Location Loc Oty ST069 83 51602 83 110 Each

4,191.000



Location	Loc Oty
ST300	4191
113422	68
114523	28
114718	95
114784	2000
115108	2000

Dart Aei	rospace	Ltd						• • • •
W/O:		W	ORK ORDER CHANGES					4)
DATE	STEP	PROCEDURE CHA	INGE	Ву	Date	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	:			!				
Part No	•	PAR #: Fault Cate	egory:NC	R: Yes	No DQ	A:	Date: _	
	Re	solution: Dispositio	on: QA	: N/C C	Closed:		Date:	
NCB:		WORK ORD	ER NON-CONFORMANCE	E (NC	R)			

NCR:	WORK ORDER NON-CONFORMANCE (NCR							
		Description of NC		Corrective Action Section B		Verification		A=====1
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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Wednesday, July 14, 2010 9:17:50 AM

Work Order ID: 60561

Parent Item:

K10003

Parent Item Name: Saddle, D205-634-011



Start Date: 7/14/2010

Required Date: 7/22/2010

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Start Qty: 4.00

Required Qty: 4.00



Purchased

No

110

1,283.000 Each

Location	Loc Qty	Loc Code	
FG	40		
104603	40		
ST301	1243		
112492	25		
113069	8		
114348	410		
114523	500		20
114784	300		

W/O:			WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									1
Part No):	PAR	#: Fault Category:	NCF	R: Yes	No DQ	A:	Date: _	
			Disposition:						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A		Corrective Action Section B	Verification	Annessai	Ammunual		
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	

DART AEROSPACE LTD.



D205-634 Page 10 of 10

5.0 **PARTS LIST**

item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X	-0.0				D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		Х			D205-634-041	SKIDTUBE
	<u>-</u> -	1		$\overline{\mathbf{x}}$	i	D205-634-045	SKIDTUBE
	1	1			Х	D205-641-011	GROUND HANDLING KIT
	<u>.</u>					=======================================	205 SKIDTUBE ASSEMBLY (STANDARD)
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD) 205 SKIDTUBE ASSEMBLY (MODIFIED)
1				1	<u> </u>	D2580-045	* PLUG
2A			16	16		D2594-1	
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER * WEARSHOE (REPLACES D2577-1)
6A			11	1_1_		D3564-9	
6B			1	1_1_		D3566-1	* GASKET
7A			11	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	11		D3566-1	* GASKET * WEARSHOE (REPLACES D2577-5)
A8			11	1		D3564-5	
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			11	1	ļ	D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50	<u> </u>	ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1		 		D2571	SADDLE, FWD OUTSIDE
20	1 1	1	<u> </u>	 		D2572	SADDLE, FWD INSIDE
21	1 1	1 1	 	-		D2573	SADDLE, AFT OUTSIDE
22	1	1	<u> </u>	 	 	D2574	SADDLE, AFT INSIDE
23	8	8		 	 	AN4-51A /	BOLT
24	16	16	 -	-	 	D2570 7	BUSHINGS
25		8	 	 	 	MS21042L4	NUT (OR MS21042-4)
26	8	8	 	+-	 	AN6-12A	BOLT
27	8	8	ļ.——	 	 	AN960JD616/	WASHER
28	8	16		 		AN4-6A	DOLT
29 ,	16	32	 	<u> </u>	 	AN960JD416 /	WASHER
30_	32	16	<u> </u>	 		MS21042L4	FNUT (OR MS21042-4)
31	16	4	 	1	+	D2747 /	SET SCREW
32	4	2	 	 		D3533-1	SET SCREW
33	2	 	- -	 	-		
40	1	1		1		D3407-041	TOW RING (REPLACES D2968-041)
41	1	1		T		D3456-1 i	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5	WASHER
					— —	D2405 044	LUG ASSEMBLY (REPLACES D2736-1)
50		ļ	ļ		1 1	D3405-041 ·	LUG ASSEMBLY (REPLACES D2736-3)
51	L	<u> </u>			1	D3405-043	
52				ļ <u>-</u>	1 4	AN4C47A	BOLT
53	<u> </u>				8	D2570 /	BUSHING AND
54					4	MS21043-4	NUT (OR MS21042-4)
<u> </u>						•	
60	2	2			T.	D2876	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: F

Date: 08.10.07